

Work Order ID 116259

116259

Page 1

April-09-14 1:01:07 PM

Item ID: D412-698-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 4/09/14 Start Qty: 2.00

**

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 2.00

**

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-09

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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IIN D412-698	Rev E
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11.12.

MLJ 14-07-04

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

DAS
JUL 17 2014
9-89

2x 14-07-17

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x

DAS
28
9-89

JUL 04 2014

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
JUL 17 2014
9-89

2x

14-07-17

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Item ID: D412-698-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 4/09/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2	8		14-07-17
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011								
	Location: 034								
	Rev								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-07-17

mf
14-7-17

Picklist Print

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Work Order ID: 116259

116259

Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 4/09/14

Required Date: 4/23/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 Bracket Assembly		Manufactured	No			100	Each	12.0000	3	6			
											DAS 28 9-89	JUL 07 2014	DAS 06 9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST235A

12

110747

2

111511

8

95390

2

116975x4

2x

D3121-143

Manufactured No

110

Each

5.0000

1

2

DAS
28
9-89

DAS
06
9-89

D3121-143

Bracket Assembly

DAS
31
9-89

Location

Loc Qty

Loc Code

ST235A

5

107802

1

94214

4

2x

D3183-043

Manufactured No

110

Each

15.0000

1

2

DAS
28
9-89

DAS
06
9-89

D3183-043

Bracket Assembly

DAS
31
9-89

Location

Loc Qty

Loc Code

ST235B

15

105803

15

B-117363
2x

Picklist Print

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Work Order ID: 116259

116259

Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 4/09/14

Required Date: 4/23/14

Start Qty: 2.00

Required Qty: 2.00

D3137-043

Manufactured No

110

Each

4.0000

1

2

**

DAS

28

9-89

JUL 04 2014

DAS

06

9-89

2 *D3137-043*

Bracket Assembly

Location

Loc Qty

Loc Code

ST235A

4

111456

4

2x

D3199-1

Manufactured No

110

Each

0.0000

9

18

**

DAS

28

9-89

10x 72x 73

DAS

06

9-89

2 *D3199-1*

Bracket

DAS

31

9-89

DAS

31

9-89

D3202-1

Manufactured No

110

Each

20.0000

1

2

**

DAS

28

9-89

DAS

06

9-89

2 *D3202-1*

Cover

DAS

31

9-89

Location

Loc Qty

Loc Code

ST241A

20

110820

20

2x

April-09-14 1:01:11 PM

Shop Packet Print

Page 2

DAS
31
9-89

14-07-17

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01